

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020510**Date Inspected:** 07-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #14

This QA Inspector observed the following work in progress

Flux Cored Arc Welding (FCAW)

Weld joint 006, Located on Deck Panel to Diaphragm to Floor beam, SEG3011B. Welder is identified as 066041. ZPMC Quality Control Inspector (QC) is identified as Gong wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Weld joint 006, Located on Deck Panel to Diaphragm to Floor beam, SEG3011F. Welder is identified as 214945. ZPMC Quality Control Inspector (QC) is identified as Gong wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Weld joint 154, Located on Floor beam, in Lift 13CE, SEG3011. Welder is identified as 052696. ZPMC Quality Control Inspector (QC) is identified as Gong wei. The welding variables recorded by QC appeared to comply with

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the WPS-B-T-2233-ESAB.

Shielded Metal Arc Welding (SMAW):

Weld joint 124, Located on Deck Panel to Diaphragm, DP 3176-001. Welder is identified as 066888. ZPMC Quality Control Inspector (QC) is identified as Zhong Lin. The welding variables recorded by QC appeared to comply with the WPS-B-P -2212-TC-U4B-FCM.

Weld joint 150, Located on SEG 3009F. Welder is identified as 067571. ZPMC Quality Control Inspector (QC) is identified as Zhong Lin. The welding variables recorded by QC appeared to comply with the WPS-B-P -2214-B-U2-FCM-1.

Bay #19

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG) in Bay 19;

Suspender Bracket SB 106E, SB 106W, SB 108E

Bike path BK004B-001

This QA observed that ZPMC was not performing any work on the above mentioned components during the time, this QA inspectors was present.

Bay #16

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG) in Bay 16;

Bottom plate BP3095

This QA observed that ZPMC was not performing any work on the above mentioned components during the time, this QA inspectors was present.

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

Inspected By:	Baskar, Govindarajan
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Quality Assurance Inspector

Reviewed By:	Clifford, William
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QA Reviewer
